

W/O: 61034		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-9-8	190.	- put D3414-1 x 6 <u>61034</u> in stock Eric Laroque's booth	MF	09-10- 10-09-01.	6.		

Part No: D3414-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61034

August 4, 2010 1:37:22 PM



Page 2

Item ID: D3414-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 8/04/10

Start Qty: 12.00



Cust Item ID:

Required Date: 8/13/10

Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/05/05

(X17)

130

0.00



Brake NC

Memo

0.00

Brake NC

1-Deburr

2-Form using DT8254 as per Dwg D3414

SD 10/08/05

(17)

No more

140

0.00



Large Fab

Memo

0.00

Large Fab

1- Weld using location Jig DT8484 as per Dwg D3414
A/R S.S. welding rod Batch: 101744

FL 10-8-16 (X11)

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Work Order ID 61034

August 4, 2010 1:37:22 PM

Page 3

Item ID: D3414-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug Assembly

Start Date: 8/04/10

Start Qty: 12.00

Cust Item ID:

Required Date: 8/13/10

Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

(11) 80 1008.7

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

81008.7

(44)

165

0.00



SprayPaint

Memo

0.00

Spray Painting

Spray paint Delfleet Blue

Primer B 110191
Delfleet Blue B 113171
Delfleet Clear B 113314

ml 10 09 07 (11)

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Work Order ID 61034

August 4, 2010 1:37:22 PM



Page 4

Item ID: D3414-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 8/04/10 Start Qty: 12.00



Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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166

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

85 10 - 07 - 08 (X11)

190

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/10/08 11 Ro

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/08

MF 10-9-08

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NOTE: Date & initial all entries

Picklist Print

August 4, 2010 1:37:26 PM

Page 1

Work Order ID: 61034



Parent Item: D3414-041



Parent Item Name: Lug Assembly

Start Date: 8/04/10

Required Date: 8/13/10

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S12GA

Purchased

No

100

sf

189.0000

0.155

1.86

2.7
10-8-5



304/316 0.100" Sheet

Location

Loc Qty

Loc Code

MAT19

189

112611

29

113062

128

113077

32

112710

140

Each

24.0000

1

12

112290

E2 10-8-16

(17)

D3414-3

Manufactured

No



Lug

Location

Loc Qty

Loc Code

WA

24

52652

5

53355

19

11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	41034
Description: Lug Bracket		Part Number:	D3414-1
Inspection Dwg: D3414 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.313	+0.006/-0.001	0.313	X		V 1002	
1.19	+/-0.030	1.184	Ø		V	
1.00	+/-0.030	1.009	Ø		V	
3.38	+/-0.030	3.377	Ø		V	
5.350	+/-0.010	5.351	↑		V	
6.23	+/-0.030	6.227	Ø		V	
2.500	+/-0.010	2.499	X		V	
0.37	+/-0.030	0.367	X		V	
0.100	+/-0.010	0.102	Ø		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-8-5	Date: 10/08/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3414-041	KJ/DD	
B	09.05.27	Dimensions updated per Dwg Rev B	KJ	
C	09.10.16	Dwg Rev updated to Rev C	KJ	

W/O:		WORK ORDER CHANGES					
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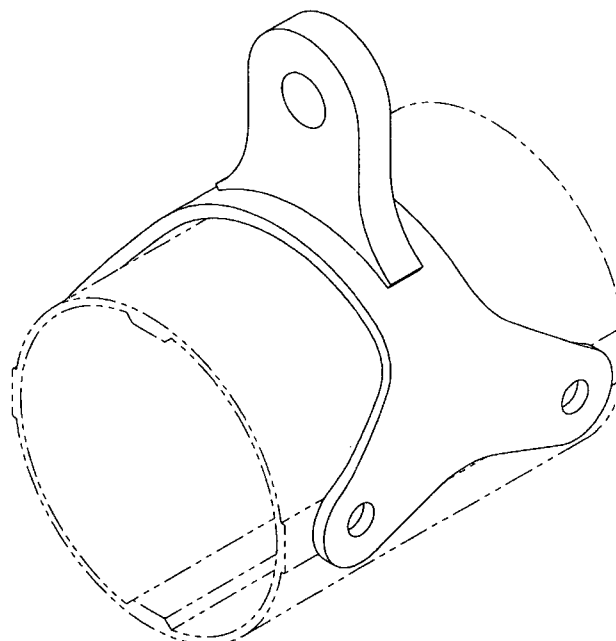
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ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

1039 8-8-01
NO WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

RELEASED
8/10/08/08/08

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

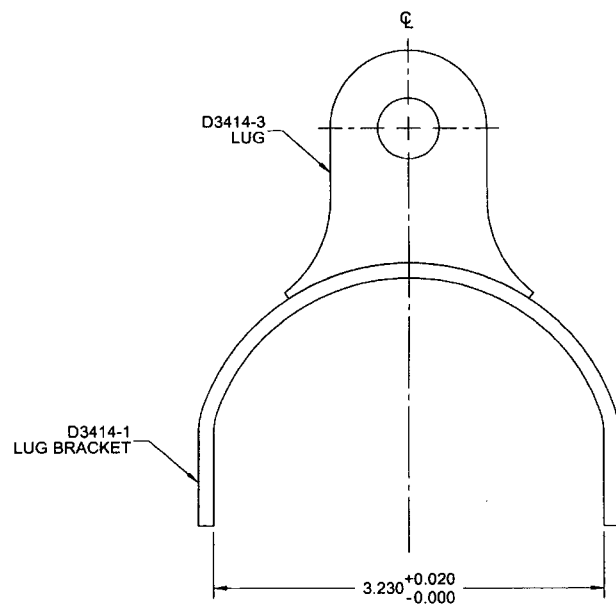
W/O:		WORK ORDER CHANGES					
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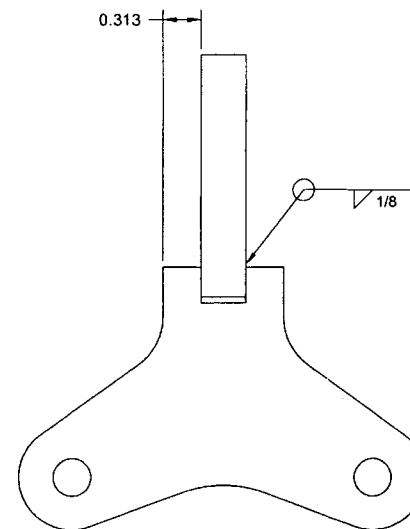
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D3414-041 LUG ASSEMBLY



w/o 61034

RELEASED

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 2 OF 3
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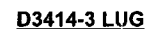
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7) WEIGHT: N/A

RELEASED

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